

Date: Thursday, 2/14/2008 2:21:04 PM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 37452C		
Estimate Number	: 10356		
P.O. Number	:	Part Number	: D2279
This Issue	: 2/14/2008 S.O. No. :	Drawing Number	: D2279 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 36710C	Material	:
Written By	:	Due Date	: 2/25/2008 Qty: 12 Um: Each
Checked & Approved By	: <u>08 0214</u>		
Comment	: Est Rev: A New Issue 05-11-07 JLM Est Rev: B Now on Waterjet 06-07-03 JLM		

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S040 2024-T3 .040 sheet



Comment: Qty.: 0.1544 sf(s)/Unit Total : 1.8522 sf(s)  
Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick  
(M2024T3S.040)  
Identify as D2279  
Batch: 100772 188-2-20

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET  
1-Cut as per Dwg D 2279  
Dwg Rev: D  
Prog Rev: D

18 8-2-20

(18)

2-Deburr if necessary 18 8-2-20

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

18 8-2-20

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

106 5-20

(18)  
counted.

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE  
Form As per Dwg D2279

513 08/03/24

PTD

(17)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2279 PAR #: NA Fault Category: Prod / Machines NCR: Yes No DQA: D Date: 28/04/04  
 QA: N/C Closed: D Date: 06/04/04

NCR: <u>37452C</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>02/03/26</u>	<u>5</u>	<u>1 part was out of tolerance at the w-l-up</u>	<u>[Signature]</u> <u>02/03/26</u>	<u>Scrap - destroy</u> <u>QTY (XL)</u>	<u>SB</u> <u>02/03/26</u>	<u>[Signature]</u> <u>02/03/27</u>	<u>[Signature]</u> <u>02/03/26</u>	<u>[Signature]</u> <u>02/03/26</u>
		<u>R. Vennan ena</u>						

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 2:21:05 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 37452C

Part Number: D2279

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/27 X17

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08/03/27 (17)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-27 (17)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Sylork

08/03/28 (17)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/02

Job Completion



mk 08-03-28  
U

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

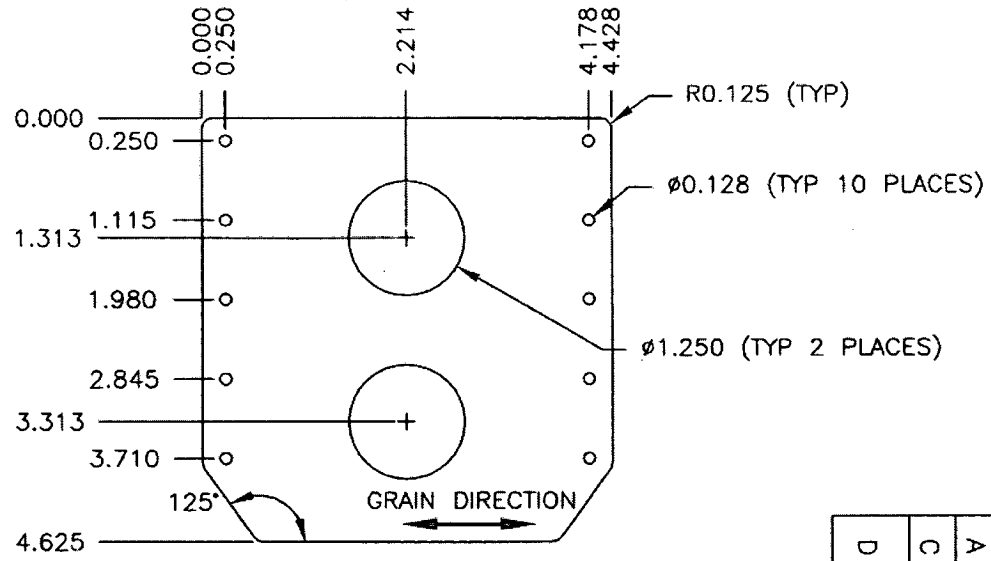
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

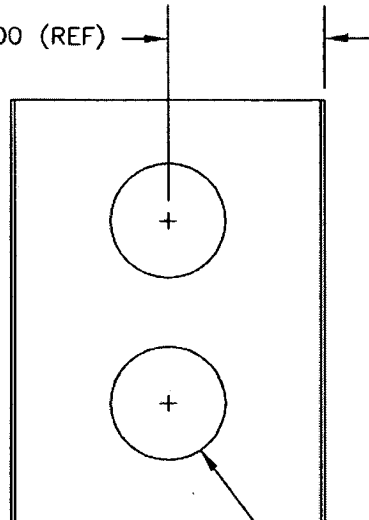




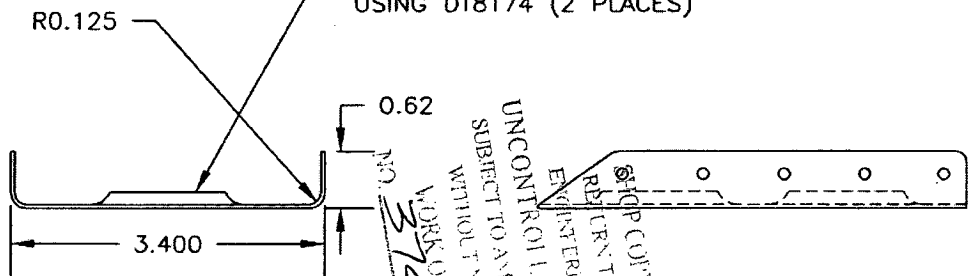
DESIGN		DRAWN BY		DART AEROSPACE LTD	
BW		JP		HAMKESBURY, ONTARIO, CANADA	
CHECKED	KE	APPROVED	MM	DRAWING NO.	D2279
DATE	98.10.05	TITLE	STEP SPACER	REV. D	SHEET 1 OF 1
			SCALE	1:2	
A	94.10.13	NEW ISSUE			
C	94.11.15	0.588 WAS 1.607 AND 3.861 WAS 4.881			
D	98.10.05	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912			



FLAT LAYOUT



FLANGE AFTER BENDING  
TOWARDS INSIDE OF PART  
USING DT8174 (2 PLACES)



RELEASED  
98.10.08 DS

UNDER REVIEW

DESIGN OK, BUT CHECK WITH  
TS BEFORE MANUFACTURE  
OK 09/11/04

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED